

Date: Thursday, 11/9/2006 4:36:59 PM  
 User: Kim Johnston

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : HELI-ACCESS STEP RH (FOLDING)
<b>Job Number</b> : 29385	
<b>Estimate Number</b> : 12568	
<b>P.O. Number</b> : N/A	<b>Part Number</b> : D412630034
<b>This Issue</b> : 11/9/2006 <b>S.O. No.</b> : N/A	<b>Drawing Number</b> : IIN D412-630 REV K
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : N/A <b>Type</b> : LARGE FAB ASSY	<b>Drawing Revision</b> : K
<b>Previous Run</b> : N/A	<b>Material</b> : N/A
<b>Written By</b> : <u>JA 061110</u>	<b>Due Date</b> : 11/27/2006 <b>Qty:</b> 3 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JA 061110</u>	
<b>Comment</b> : Est. Rev: A New Issue 06-11-08 JLM	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	DC	DOCUMENT CONTROL
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**Comment:** DOCUMENT CONTROL

Photocopy bluefile &amp; create labels per PPP D412-630-034 CHG001

KS 06.11.13

2.0	D2012107	Clevis
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Clevis

Pick:

Qty	Part Number	Description	Batch
1	D2012-107	Clevis	B 27522 -

3.0	D2803042	Bracket Assembly
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Bracket Assembly

Pick:

Qty	Part Number	Description	Batch
1	D2803-042	Bracket Assembly RH	B 29392 -

B 29392 -

B 26544 - B 27283 -

REFERENCE ONLY

4.0	D2804042	Bracket Assembly
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Bracket Assembly

Pick:

Qty	Part Number	Description	Batch
1	D2804-042	Bracket Assembly RH	B 26252 -

B 26252

B 25920 x2 -

mf 07-03-26

Date: Thursday, 11/9/2006 4:37:00 PM  
User: Kim Johnston

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Job Number: 29385

Part Number: D412630034

Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0	D2807	Support Prop
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Support Prop

Pick:

Qty	Part Number	Description	Batch
2	D2807	Gas Spring	B 28488 -

6.0	D2813	Washer
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description	Batch
2	D2813	Washer	B 29396 -

7.0	D3562042	STEP ASSEMBLY, RH
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Step Weldment LH

Pick:

Qty	Part Number	Description	Batch
1	D3562-042	Step Weldment RH	B 30575 B 31445 ✓

8.0	D33951	Bushing
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Bushing

Pick:

Qty	Part Number	Description	Batch
4	D3395-1	Bushing	B 28455 -

9.0	AN3C21A	BOLT
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

BOLT

Pick:

Qty	Part Number	Description	Batch
2	AN3C21A	Bolt	M101189 -

MF: 07-03-26

Date: Thursday, 11/9/2006 4:37:00 PM  
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Job Number:



Seq. #:	Machine Or Operation:	Description :
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10.0	AN8C16	Bolt
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description
2	AN8C16	Bolt

Batch

M100695-

11.0	AN310C8	Nut
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Nut

Pick:

Qty	Part Number	Description
2	AN310C8	Nut

Batch

M100433-

12.0	MS24665302	Cotter Pin
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Cotter Pin

Pick:

Qty	Part Number	Description
2	MS24665-302	Cotter Pin (or AN380C3-4)

Batch

M16941-

13.0	NAS1515H3	Washer
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Comment: Qty.: 6.0000 Each(s)/Unit Total : 30.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description
6	NAS1515H3	Washer

Batch

M100993-

14.0	NAS1515H5L	WASHER
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

WASHER

Pick:

Qty	Part Number	Description
4	NAS1515H5L	Washer

Batch

M100680-

MF. 07-03-26

Date: Thursday, 11/9/2006 4:37:00 PM  
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Job Number: 29385

Part Number: D412630034

Job Number:



Seq. #:	Machine Or Operation:	Description :
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15.0	NAS1515H8	Washer
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description
4	NAS1515H8	Washer

Batch

M101331 -

16.0	MS210433	Nut
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Nut

Pick:

Qty	Part Number	Description
4	MS21043-3	Nut

Batch

M102545 -

17.0	MS24693C280	Screw
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Screw

Pick:

Qty	Part Number	Description
2	MS24693-C280	Screw (or MS24694-C565)

Batch

M101390 -

MF 07-03-26

18.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg D412-630 p.14

Coat all hardware with LPS3 rust inhibitor

A/R LPS3 batch: M101472

COAT exposed HARDWARE WITH LPS PROCYON .

A/R LPS PROCYON

BATCH: M17045

MF

07-03-26

19.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

07/03/26 (3)

Date: Thursday, 11/9/2006 4:37:00 PM  
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Part Number: D412630034

Job Number:



Seq. #: Machine Or Operation: Description :

20.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

SO 07/03/25

21.0

D28061

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

Bushing

Pick: Packing Kit

Qty Part Number

Description

Batch

2

D2806-1

Bushing

B25921 2X B27285 4X

22.0

D28063

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

Bushing

Pick: Packing Kit

Qty Part Number

Description

Batch

2

D2806-3

Bushing

B26160 2X B27286 4X

23.0

D28105

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Strut

Pick: Packing Kit

Qty Part Number

Description

Batch

1

D2810-5

Strut

B26758 1X B27287 2X

24.0

D33961

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

Spacer

Pick: Packing Kit

Qty Part Number

Description

Batch

2

D3396-1

Spacer

B26654 2X B27290 4X

25.0

AN4C6A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Bolt

Pick: Packing Kit

Qty Part Number

Description

Batch

7/03/25 SO

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Job Number: 29385

Part Number: D412630034

Job Number:



Seq. #: Machine Or Operation: Description :

1 AN4C6A Bolt

M19512 3X

26.0 AN4C10A Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Bolt

Pick: Packing Kit

Qty Part Number

Description

Batch

1 AN4C10A

Bolt

M10515 1X

M100273 2X

27.0 AN4C15A Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

Bolt

Pick: Packing Kit

Qty Part Number

Description

Batch

2 AN4C15A

Bolt

M100036 2X

M100497 4X

28.0 AN4C7A Eyebolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Eyebolt

Pick: Packing Kit

Qty Part Number

Description

Batch

1 AN44-C7A

Eyebolt

M19620 3X

29.0 AN5C15A Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

Bolt

Pick: Packing Kit

Qty Part Number

Description

Batch

2 AN5C15A

Bolt

M18167 2X

M100229 4X

30.0 NAS1515H4 Washer



Comment: Qty.: 7.0000 Each(s)/Unit Total: 35.0000 Each(s)

Washer

Pick: Packing Kit

Qty Part Number

Description

Batch

7 NAS1515H4

Washer

M105680 7X

M101428 14X

7/03/95 50

Date: Thursday, 11/9/2006 4:37:01 PM  
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Part Number: D412630034

Job Number:



Seq. #: Machine Or Operation: Description :

31.0 NAS1515H5 Washer



Comment: Qty.: 7.0000 Each(s)/Unit Total: 35.0000 Each(s)

Washer

Pick: Packing Kit

Qty	Part Number	Description
7	NAS1515H5	Washer

Batch

M19568 7X M101369 14X

32.0 MS210434 Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total: 20.0000 Each(s)

Nut

Pick: Packing Kit

Qty	Part Number	Description
4	MS21043-4	Nut

Batch

M100651 4X M101390 8X

33.0 MS210435 Nut



Comment: Qty.: 3.0000 Each(s)/Unit Total: 15.0000 Each(s)

Nut

Pick: Packing Kit

Qty	Part Number	Description
3	MS21043-5	Nut

Batch

M18535 9X

34.0 QC4 INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

35.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-630-034

Location:

PPP Rev:

DNAH

FINAL INSPECTION/W/O RELEASE

36.0 QC21



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 07.0326